

# Work Order ID 73977

Tuesday, September 20, 2011 10:23:12 AM

Page 1

Item ID: D205-770-011

Accept

Revision ID:

Item Name: Replacement Engine Mount

Start Date: 9/20/2011 Start Qty: 1.00

Required Date: 10/4/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: *mk*

Date: *11-09-20*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D205-770	Rev C
MDL-D205-770	E

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile and create labels per PPP D205-770-011

110



Packaging

Packaging

Pick Kit

0.00


Memo

0.00

*Adm MLJ 12-1-30 ①*

*Pho →*

*12/1/30*

W/O: 73977		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/1/31		ADD DSZ 9571 to KIT					S 12/1/31

Part No: D205770-011 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73977**

Tuesday, September 20, 2011 10:23:12 AM

Page 2

Item ID: D205-770-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Engine Mount

Start Date: 9/20/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 10/4/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start




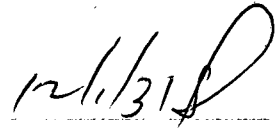

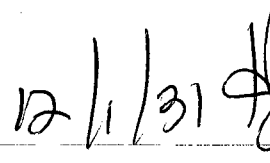
QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00		812111/31					
130  Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPP D205-770-011 CHG003 Location: <u>E</u> PPP Rev: <u>E</u>	0.00 0.00							
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							  ME 12-01-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, September 20, 2011 10:23:10 AM

Page 1

Work Order ID: 73977

Parent Item: D205-770-011

Parent Item Name: Replacement Engine Mount

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue ECN1165p 08-03-31 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3684-043 MOUNT ASSEMBLY		Manufactured	No			110	Each	1.0000	1	1			

Location Loc Qty Loc Code

ST077

1

71998

1

D3684-045 LEG ASSEMBLY		Manufactured	No			110	Each	0.0000	1	1			
D3692-1 SPACER		Manufactured	No			110	Each	41.0000	4	4			

Location Loc Qty Loc Code

ST075

41

51467

41

AN3C12A Bolts		Purchased	No			110	Each	100.0000	4	4			
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Location Loc Qty Loc Code

ST351

100

117514

4

118112

5

118422

17

118451

24

118838

50

B79003

B79002

B73237

M120423

12/1/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, September 20, 2011 10:23:10 AM

Work Order ID: 73977

Parent Item: D205-770-011

Parent Item Name: Replacement Engine Mount

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

110

Each

1,086.000

2

2



Nut



1169902 SP

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1014

118077

34

118614

500

118686

480

D3685-041

Manufactured

No

110

Each

0.0000

1

1



BIPOD MOUNT ASSEMBLY



B7899 SP

D3686-041

Manufactured

No

110

Each

2.0000

1

1



MONOPOD ASSEMBLY



B77303 SD 12/1/30

Location

Loc Qty

Loc Code

ST79

2

72001

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## 4. WEIGHT AND BALANCE

The following is the net weight increase associated with the D205-770-011 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-770-011	14.6 lb	-3.5 in	-51.1 in-lb	107.8 in	1574 in-lb
Replacement Engine Mount Kit	6.62 kg	-0.09 m	-0.6 m-kg	2.74 m	18.1 m-kg

## 5. PARTS LIST

Qty -011	Part Number	Description
X	D205-770-011	REPLACEMENT ENGINE MOUNT KIT
1	D3684-041	TRIPOD MOUNT ASSEMBLY
1	*D3684-043*	MOUNT ASSEMBLY
8	**D3692-1	SPACER
4	**AN3C-12A	BOLT
4	**MS21043-3	NUT
1	**D3687-1	MOUNT
1	**D3684-047	FWD LEG ASSEMBLY
1	***D3688-1	STUD
1	***D3689-1	SLEEVE
1	***D3691-1	STUD
4	***D3692-1	SPACER
1	***D3693-1	ROD END BEARING
2	***AN3C-12A	BOLT
2	***MS21043-3	NUT
1	***NAS509-12C	NUT
1	***NAS509L-12C	NUT
1	**D3684-049	AFT LEG ASSEMBLY
1	***D3688-3	STUD
1	***D3689-1	SLEEVE
1	***D3691-1	STUD
4	***D3692-1	SPACER
1	***D3693-1	ROD END BEARING
2	***AN3C-12A	BOLT
2	***MS21043-3	NUT
1	***NAS509-12C	NUT
1	***NAS509L-12C	NUT
1	*D3684-045	INBOARD LEG ASSEMBLY
1	**D3688-5	STUD
1	**D3689-1	SLEEVE
1	**D3691-1	STUD
4	**D3692-1	SPACER
1	**D3693-1	ROD END BEARING
2	**AN3C-12A	BOLT
2	**MS21043-3	NUT
1	**NAS509-12C	NUT
1	**NAS509L-12C	NUT
4	*D3692-1	SPACER
2	*AN3C-12A	BOLT
2	*MS21043-3	NUT

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Revision: C

Date: 10.05.20

# REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D205-770

Page 11 of 11

continued from previous page...

Qty -011	Part Number	Description
<b>1</b>	<b>D3685-041</b>	<b>BIPOD MOUNT ASSEMBLY</b>
1	*D3687-3	MOUNT
1	*D3684-047	FWD LEG ASSEMBLY
1	**D3688-1	STUD
1	**D3689-1	SLEEVE
1	**D3691-1	STUD
4	**D3692-1	SPACER
1	**D3693-1	ROD END BEARING
2	**AN3C-12A	BOLT
2	**MS21043-3	NUT
1	**NAS509-12C	NUT
1	**NAS509L-12C	NUT
1	*D3684-049	AFT LEG ASSEMBLY
1	**D3688-3	STUD
1	**D3689-1	SLEEVE
1	**D3691-1	STUD
4	**D3692-1	SPACER
1	**D3693-1	ROD END BEARING
2	**AN3C-12A	BOLT
2	**MS21043-3	NUT
1	**NAS509-12C	NUT
1	**NAS509L-12C	NUT
8	*D3692-1	SPACER
4	*AN3C-12A	BOLT
4	*MS21043-3	NUT
<b>1</b>	<b>D3686-041</b>	<b>MONOPOD ASSEMBLY</b>
1	*D3688-7	STUD
1	*D3689-1	SLEEVE
1	*D3691-1	STUD
4	*D3692-1	SPACER
4	*D3692-3	SPACER
1	*D3693-1	ROD END BEARING
1	*D3693-3	ROD END BEARING
2	*AN3C-10A	BOLT
2	*AN3C-12A	BOLT
4	*MS21043-3	NUT
1	*NAS509-12C	NUT
1	*NAS509L-12C	NUT

(NOTE: PARTS IN BOLD TYPE CONSTITUTE PICK LIST FOR D205-770-011 KIT)

\* PART IS INCLUDED WITH ASSEMBLY ABOVE

\*\* PART IS INCLUDED WITH ASSEMBLY ABOVE

\*\*\* PART IS INCLUDED WITH ASSEMBLY ABOVE














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Revision: **C**  
Date: 10.05.20

Part Number D205-T70-011  
Description REPLACEMENT ENGINE MOUNT

Part Number D205-T70-011  
Description REPLACEMENT ENGINE MOUNT

[illegible]

Item ID	Rev	Name	Start Date	Quantity Per	UOM	Route Seq ID	Scrap %	Comments	Sort	Date Last Mod
D3688-7		STUD	12/5/2009	1.0000	Each	100	0 %		1	12/5/2011 8:50 AM
D3689-1		SLEEVE	12/5/2009	1.0000	Each	100	0 %		2	12/5/2011 8:50 AM
D3691-1		STUD	12/5/2009	1.0000	Each	100	0 %		3	12/5/2011 8:50 AM
D3692-1		SPACER	12/5/2009	4.0000	Each	100	0 %		4	12/5/2011 8:50 AM
D3692-3		SPACER	12/5/2009	4.0000	Each	100	0 %		5	12/5/2011 8:50 AM
D3693-1		Rod End Bearing	12/5/2009	1.0000	Each	100	0 %		6	12/5/2011 8:50 AM
D3693-3		Rod End Bearing	12/5/2009	1.0000	Each	100	0 %		7	12/5/2011 8:50 AM
AN3C10A		Bolt	1/1/2008	2.0000	Each	100	0 %		8	12/5/2011 8:50 AM
MS21042-3		USE MS21042L3	12/5/2011	2.0000	Each	100	0 %		9	12/5/2011 8:50 AM
MS21043-3		Nut	1/1/2008	2.0000	Each	100	0 %		10	12/5/2011 8:50 AM
NAS509L12C		Nuts	1/1/2008	1.0000	Each	100	0 %		11	12/5/2011 8:50 AM
NAS509-12C		Nuts	8/11/2009	1.0000	Each	100	0 %		12	12/5/2011 8:50 AM
MS21250-03014		BOLT	12/5/2011	2.0000	Each	100	0 %		13	12/5/2011 8:50 AM
								